Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-163 **Date Opened:** 02 October 2017 **Title:** Fabrication

Aircraft OEM: Bell **Aircraft Model:** 407 **Product Type:** Cargo Basket **Product Model:** High Ski **Quantity:** 7

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	CB/JC
Completed Certification	CB/JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	CB/JC
Dual Inspections Initialled	CB/JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76611	1	Basket Body	JC
76612	0	Lid	JC
76623	1	Hoop	JC
76624	0	Forward Mount Hoop	JC
76625	0	Aft Mount Hoop	JC
84262	2	Basket Handle Prov.	JC
84263	0	Lid Handle Provisions	JC
70405	4	Lid Walkway	JC

Component Completion

	As Instructed
Quantity Complete on This Work Order	7
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	DM
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by: Print: Jason Rekve Sign: SCA: AD 01 Date: 2-Oct-17

ICC / Dual Inspection preformed by: Print: Jeff Clarke Sign: SCA: AD 02 Date: 29-Nov-17

Work Order closed by: Print: Jeff Clarke Sign: SCA: AD 02 Date: 8-Dec-17

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9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: L10 CROSS MEMBER (3/4x035 HT30) No. of pieces: 21

Manufacturer: AERO DESIGN LTD

Part No.: N/A Serial/Batch No.: PO 17055

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-163

Remaining Tasks to be Performed: NONE

Signature: Jeff Cech.

Date: 31 OCT 2017 Lic. No. / SCA AD02

Serviceable

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: LID END (3/4 x 0.035 4130) No. of pieces: 14
Manufacturer: AERO DESIGN LTD.
Part No.: N/A Serial/Batch No.: PO 17055
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2017-163
Remaining Tasks to be Performed: NONE

Signature:
Date: 31 OCT 2017 Lic. No. / SCA AD02

Serviceable

Aero Design Ltd.
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AMF 73-04

Nomenclature: HD CROSS MEMBER No. of pieces: 30

Manufacturer: AERO DESIGN LTD

Part No.: N/A -3/4 x 0.035 4130 TUBE Serial/Batch No.: 17055

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-153

Remaining Tasks to be Performed: NONE

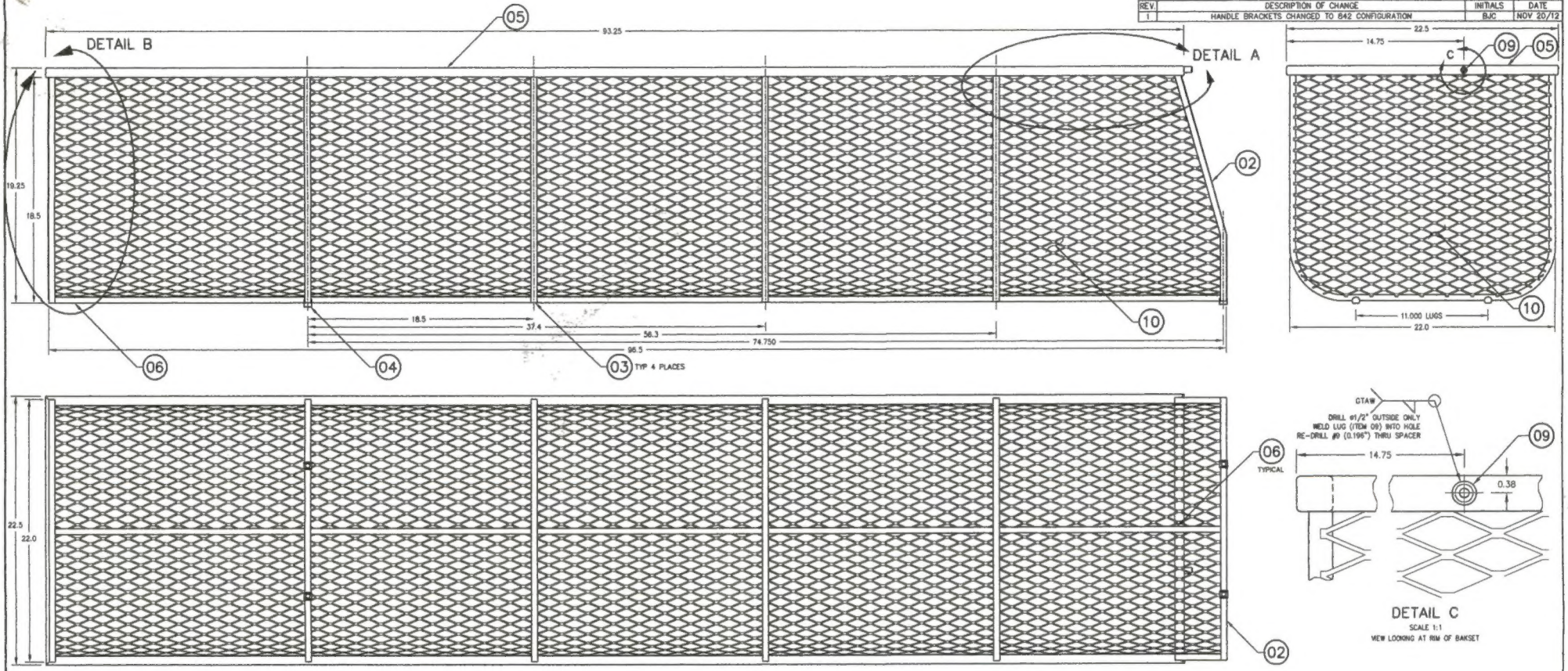
Signature: JH Cel.

Date: 20 SEPT 2017 Lic. No. / SCA ADO2

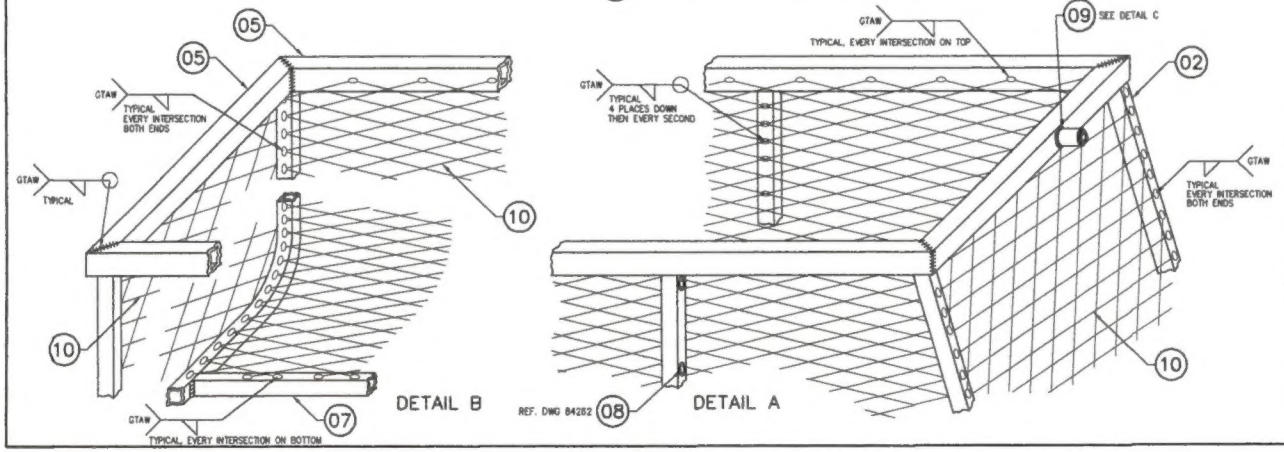
Serviceable

2017-163

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	HANDLE BRACKETS CHANGED TO 842 CONFIGURATION	BJC	NOV 20/12



(01) BASKET BODY ASSEMBLY



NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

QTY.	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
			LIST OF MATERIALS			
01	76611-01	01	BASKET BODY ASSEMBLY			
1	76621-01	02	END HOOP ASS'Y			
4	76623-01	03	HOOP			
1	76622-01	04	ATTACHMENT HOOP			
A/R	--	05	3/4" TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE
A/R	--	06	1/2" TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
		07				
1	84262-01	08	HANDLE BRACKET ASS'Y			
1	49215-01	09	LUG			
A/R	3/4-16F	10	MESH		16 GAUGE	

APPROVALS	DATE
DRAWN: JEFF CLARKE	25 SEPT 2007
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2"

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
3013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250-8027 fax: (403) 250-8355 aerodesign@telusplanet.net

BELL 407, 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
CARGO BASKET BODY ASSEMBLY

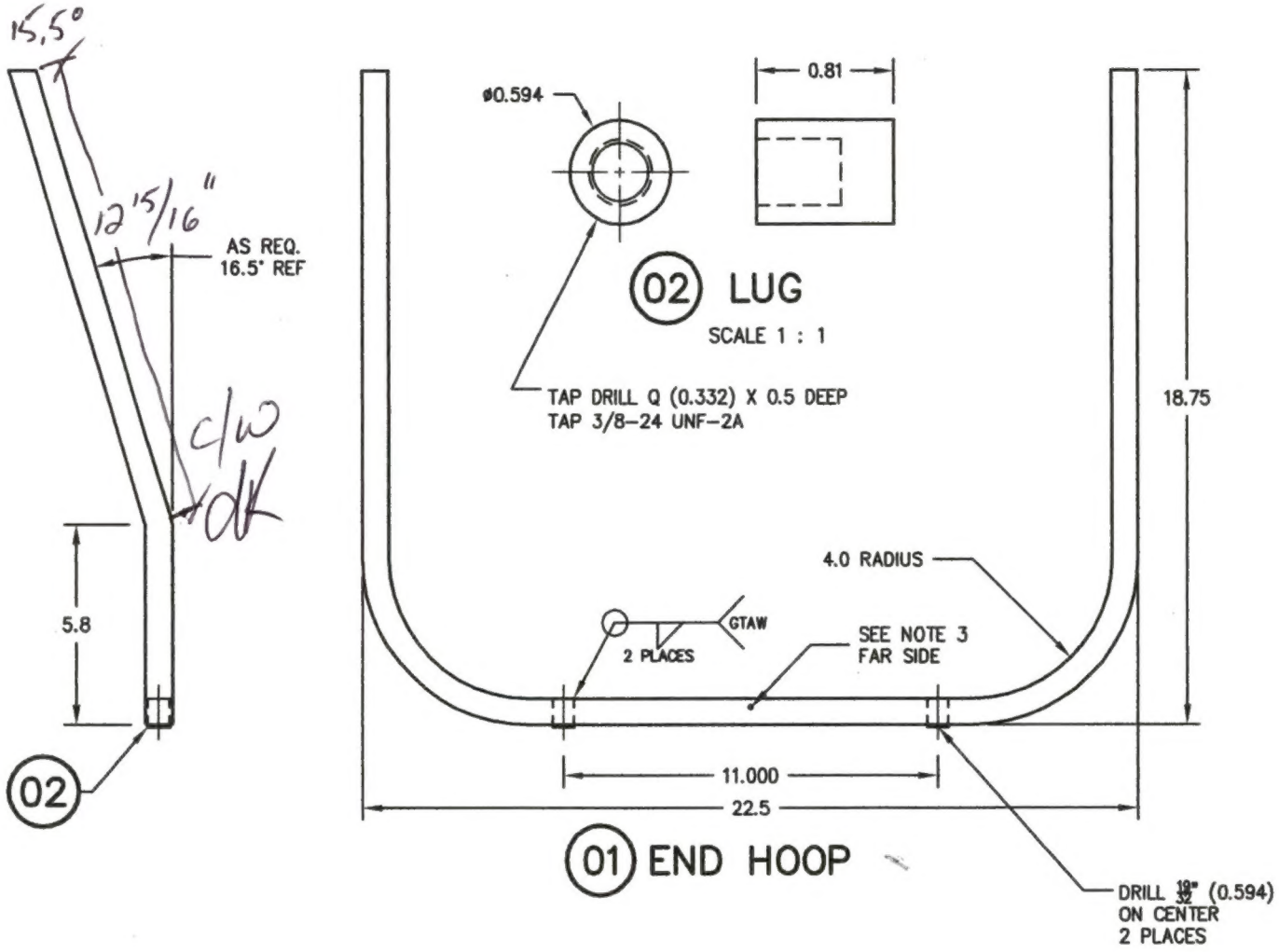
SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	76611	1

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 76621, REV. 0		

2017-163

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
   4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. DRILL #30 VENT HOLE IN BOTTOM OF HOOP FOR VENTING WELD GASES.



2	76624-02	02	LUG	1018 CARBON STEEL	ASTM A108	ø5/8" ROD
	76624-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	3/4" SQR x 0.065 WALL
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE
DRAWN:	JEFF CLARKE	25 JUNE 2017
CHECKED:	JASON REKVE	25 JUNE 2017

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

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BELL 407 AND 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
BASKET COMPONENTS – END HOOP

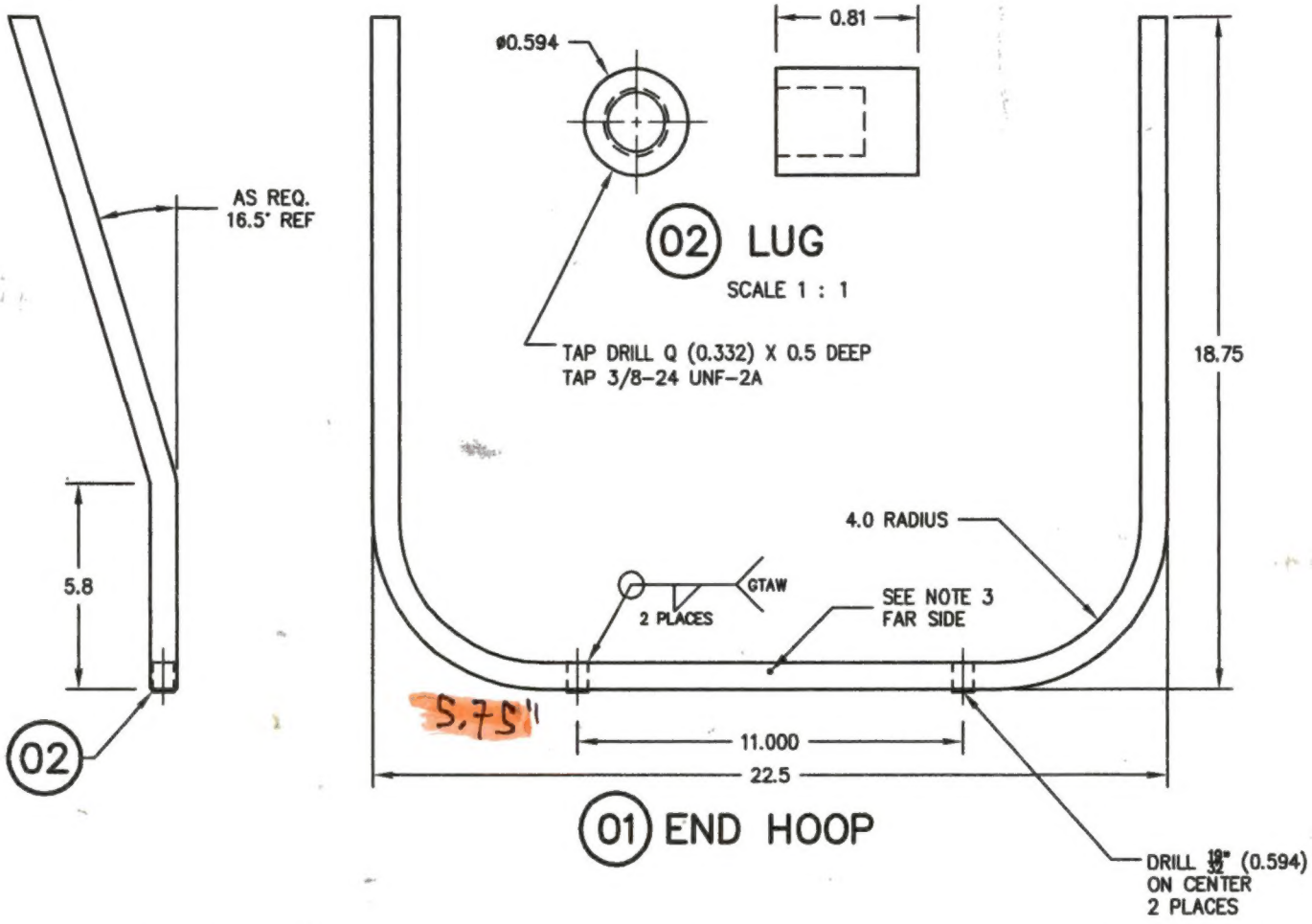
SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	76624	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 76621, REV. 0		

2017-163

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
   4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. DRILL #30 VENT HOLE IN BOTTOM OF HOOP FOR VENTING WELD GASES.



01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	76624-02	02	LUG	1018 CARBON STEEL	ASTM A108	ø5/8" ROD
	76624-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	3/4" SQR x 0.065 WALL

QTY — LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	25 JUNE 2017
CHECKED: JASON REKVE	25 JUNE 2017

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

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BELL 407 AND 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
BASKET COMPONENTS – END HOOP

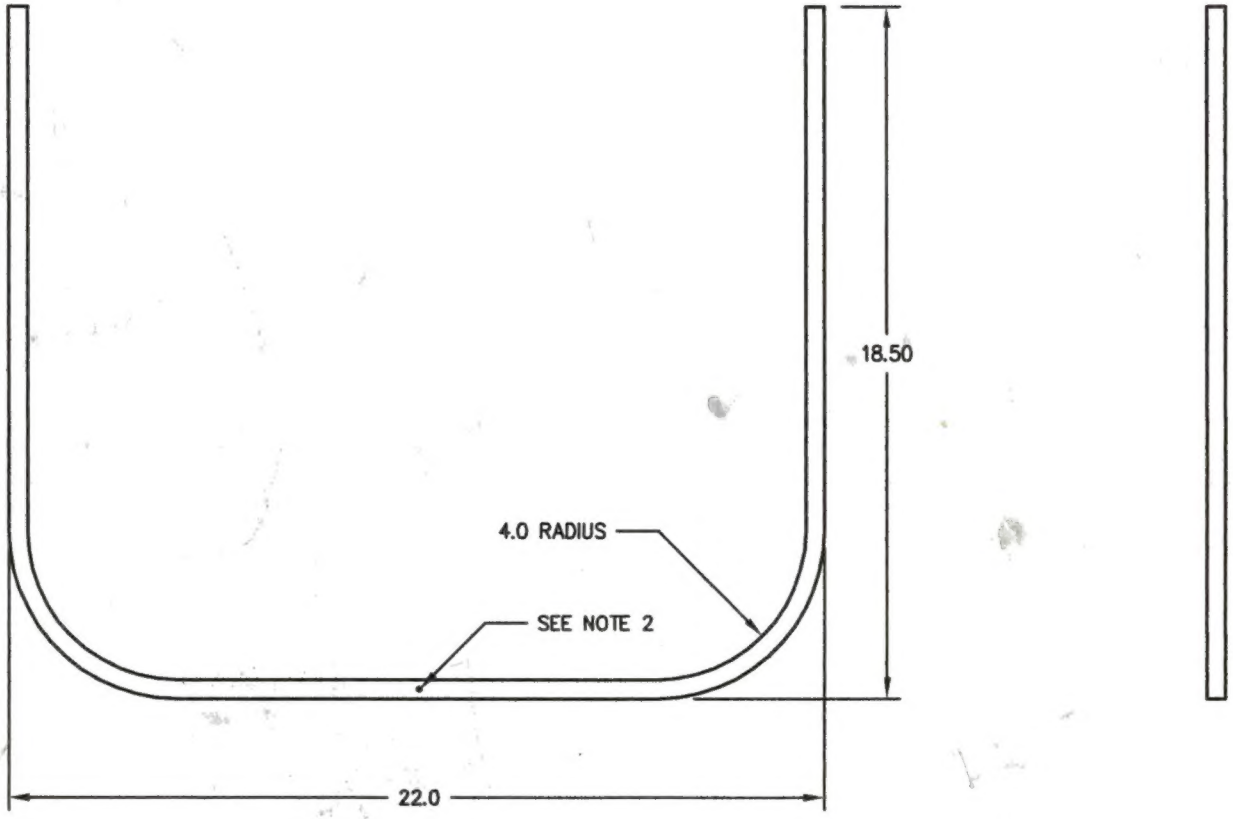
SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 5	A4	76624	0
SHEET 1 OF 1			

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; REFORMATTED TO A4; VENT HOLE SIZE CHANGED	BJC	29/09/2016

2017-163

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL #30 VENT HOLE IN BOTTOM OF HOOP FOR VENTING WELD GASES.



(01) HOOP

	76623-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2" SQR x 0.035 WALL
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE
DRAWN:	JEFF CLARKE	26 SEPT 2007
CHECKED:	E. BURGOIN	27 SEPT 2007

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

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BELL 407 AND 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
BASKET COMPONENTS – HOOP

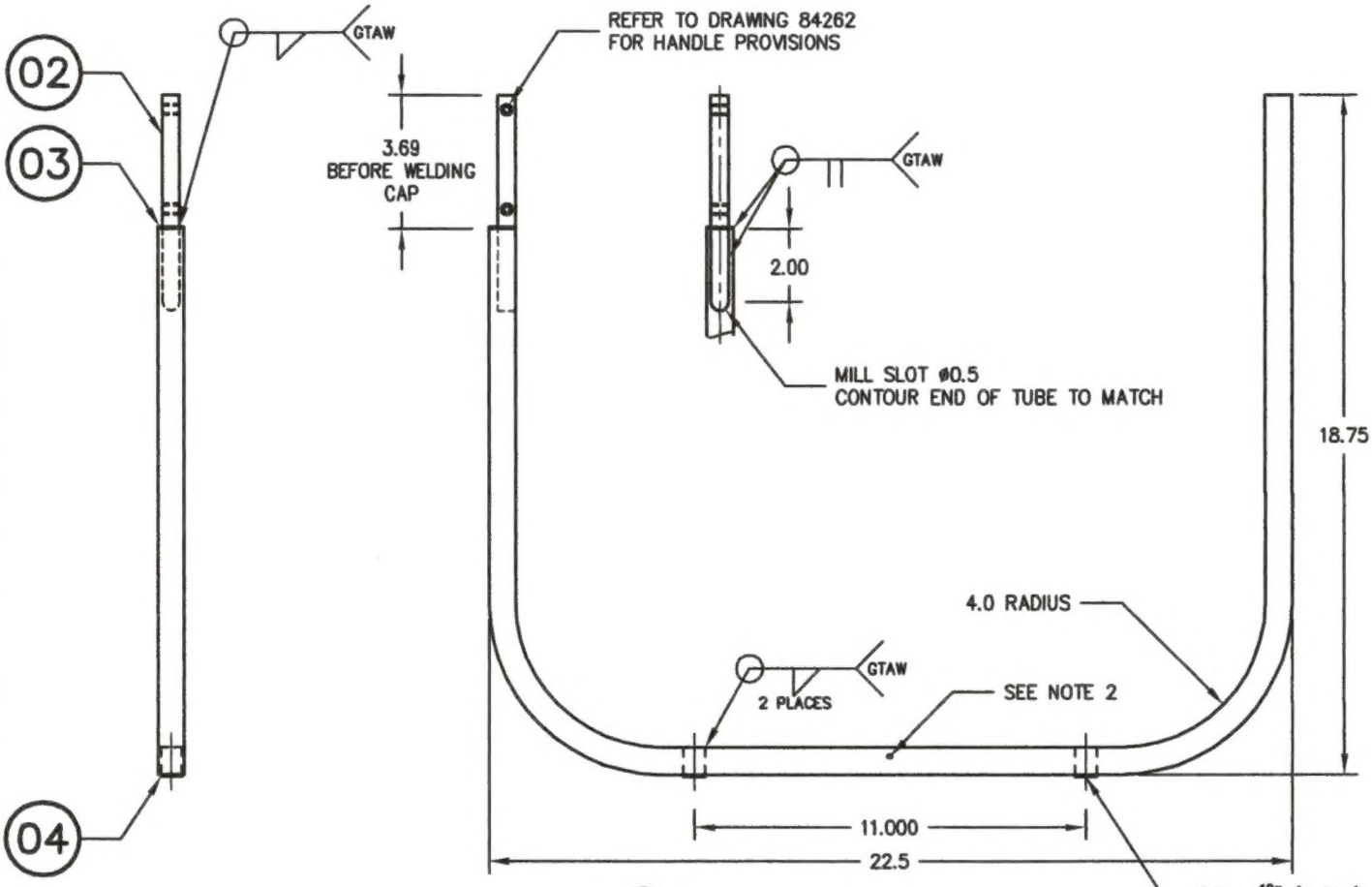
SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 1	A1	76623	1	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 76622 REV. 0		

2017-163

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
   4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. DRILL #30 VENT HOLE IN BOTTOM OF HOOP FOR VENTING WELD GASES.



01 ATTACHMENT HOOP

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	76624-02	04	LUG	1018 CARBON STEEL	ASTM A108	ø5/8" ROD
1	76625-03	03	CAP	1018 CARBON STEEL	AISI 1010-1020	0.025"-0.050" SHEET
1	76625-02	02	EXTENSION	4130 STEEL COND. N	MIL-T-6736	1/2" SQR x 0.035 WALL
	76625-01	01	ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	3/4" SQR x 0.065 WALL

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	JEFF CLARKE	25 JUNE 2017
CHECKED:	JASON REKVE	25 JUNE 2017

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

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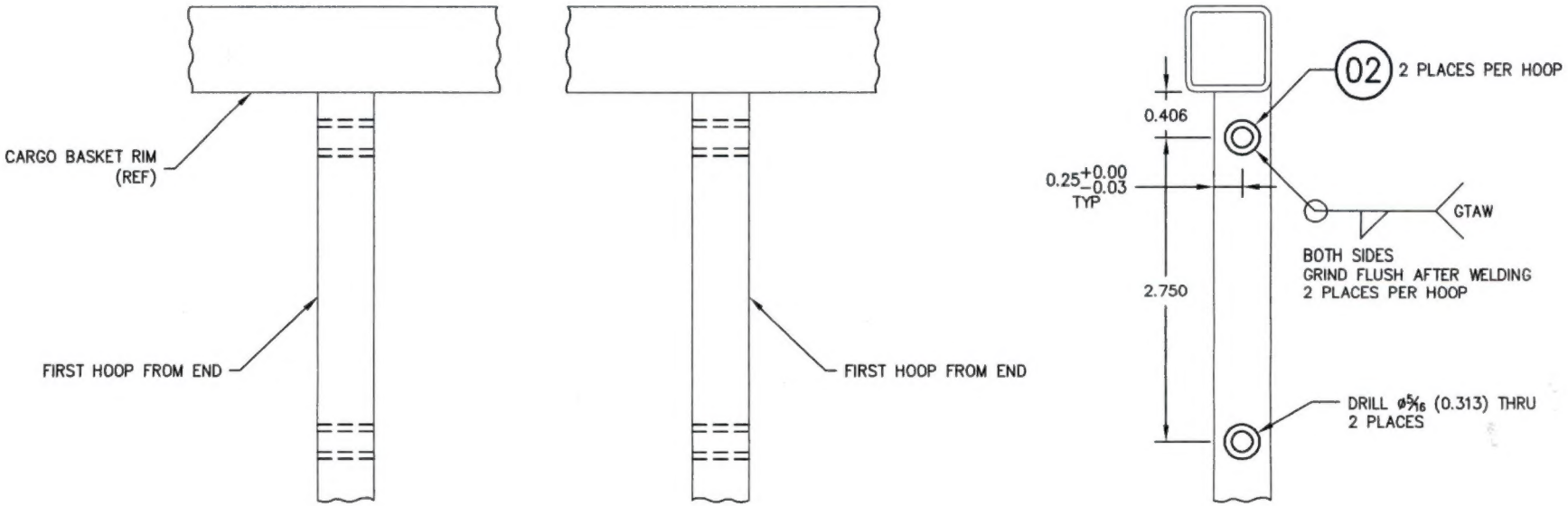
BELL 407 AND 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
BASKET COMPONENTS – ATTACHMENT HOOP

SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	76625	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014



(01) BASKET HANDLE PROVISIONS ASSEMBLY

PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

QTY	PART NO.	ITEM	DESCRIPTION
4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

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HELICOPTER CARGO BASKET
BASKET HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2

2017-163

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing
76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-163 Batch Quantity: ~~24~~ 28 JC **Complete** (initial or SCA #)

Date Open: Oct 2017 Part Number: 76624-02

1. Cut stock material: KB

   a. Enter material PO: PO: 15039
   b. Cut stock to length, + 0.03-0.06".
   c. Tag in-progress parts and place on in-progress shelf in machine shop.

2. Turn stock material: KB

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.
Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

   a. Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
   b. Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
   c. Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
   d. Setup stop and face other end to length @ 1000 RPM.
   e. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
   f. Tag complete parts.

76623 -1/2"
24 -3/4" longer
25 -3/4"

CARGO BASKET HOOP FABRICATION - 49210

General

These instructions apply to cargo basket hoop 49210-02 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

49210, Revision 1 – Basket Component - Hoop

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2017-163

Date Open: Oct 2017

Complete (initial or SCA #)

J.F. OR

1. Hoop Fabrication – 49210-02 54 1/16 JF.
   a. Cut ½" x 0.035 material to ~~48.0"~~, square ends.
   b. Record material PO on attached material list.
   c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
   d. Remove writing on tubes with acetone and scotch bright.
   e. On the hoop bending fixture, set the following stops:
      i. Upper tube stop: ~~193~~" 90° JF.
      ii. Lower bend stop: 12mm
   f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
   g. Slide shim all the way forward on bender to secure tube in die
   h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
   i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
   j. Repeat steps f.-i. for opposite end of tube.
   k. Check for: 18.5 JF
      i. hoop height: ~~15.5~~" (Outside to outside)
      ii. hoop width just above bends: 22" (outside to outside)
      iii. adjust upper stop for height if required
      iv. adjust stock length for width if required
      v. twist – due to pulling bending arm up or down through bend
   l. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
   m. Inspect hoops for conformity to drawing.
   n. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET HOOP FABRICATION - 84262

General

These instructions apply to all cargo basket hoops that require handle bracket provisions. Refer to the following drawings, at the current revision, for dimensions and details:

Handle Provisions – Common to all baskets
84262, Revision 1 – Handle Bracket Assembly

76623-01
Hoops w/ HANDLE PROV.
x7

Work Order: _____

Date Open: 2017-163 Oct 2017

Complete
(initial or SCA #)

1. Handle Bushings – Preparation – 84262-01 — AD 73-04 02
   Required in locations where handle brackets will be installed.
   a. Start with stock hoop or half hoop as required for specific basket assembly.
   b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
   c. Drill 2 places, 5/16" (0.313) holes using 5/16 (#4) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
      i. locate 0.23" from edge (within tolerance specified on drawing).
   d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
   e. Tag in process hoop(s) and place into stock.

2. Handle Bushings – Welding – 84262-01 — AD 73-04 02
   a. Insert 84271-01 bushings into hoop prepared in step 2. above.
   b. TIG weld bushing both sides, 2 bushings per hoop.
   c. Record bushing and welding rod PO/WO on attached material list.
   d. Tag in process hoop(s) and place into stock.

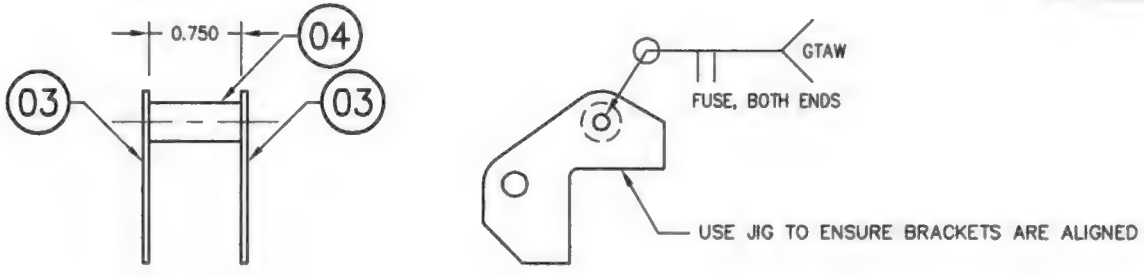
3. Handle Bushings – Finish – 84262-01 — AD 73-04 02
   a. De-burr welded bushings.
   b. Inspect hoop for conformity to drawing.
   c. Tag complete and inspected hoop(s) and place into stock.

Aero Design
Parts Distribution Sheet

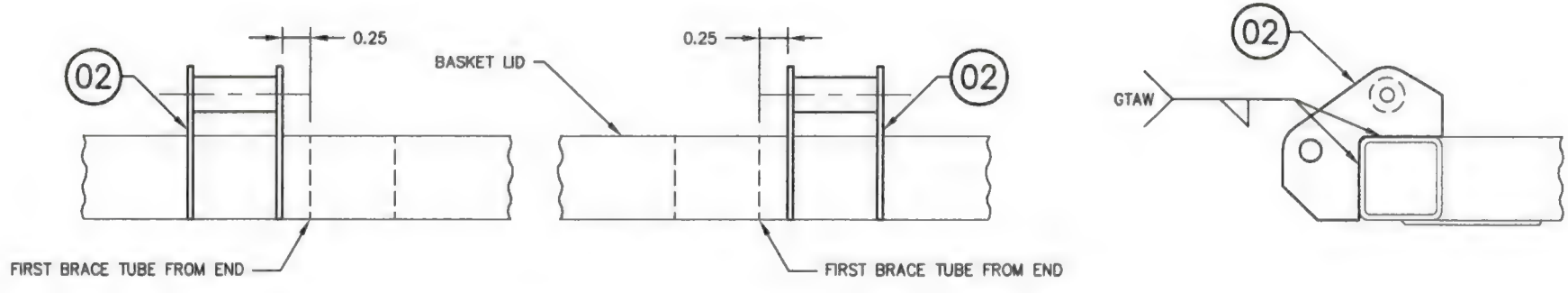
WO# 2017-163

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-163	7	½" hoops x 0.035 wall 4130 Shaft end	17082	2017-163
2016-134	28	Handle bushings	84272	2017-163
15035	7	Cap	76625-03	
16078		T.I.G. rods	ER 70S	
17082	28 @ 5¼"	½" x 0.035 wall 4130 hoops	~~17082~~	
17082	14 @ 56"	¾ x 0.065 4130 tube hoops		

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 84262 REV. 1	BJC	14/02/2014



(02) HANDLE BRACKET ASSEMBLY



(01) LID HANDLE PROVISIONS ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER308L OR EQUIVALENT.

1		36275–02	04	SUPPORT
2		36273–01	03	LID BRACKET
\	2	84263–02	02	HANDLE BRACKET ASSEMBLY
	\	84263–01	01	LID HANDLE PROVISIONS ASSY
02	01	PART NO.	ITEM	DESCRIPTION
QTY	QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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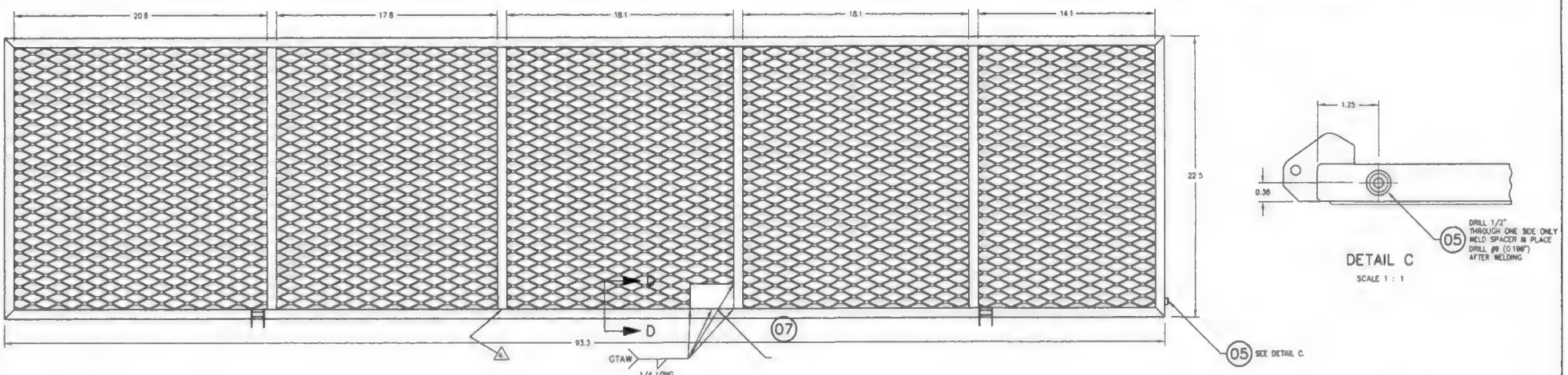
TEL: 604.485.8376 www.aerodesign.ca

HELICOPTER CARGO BASKET
LID HANDLE PROVISIONS ASSEMBLY

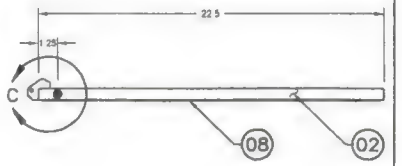
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84263	0

2017-163 X (7)

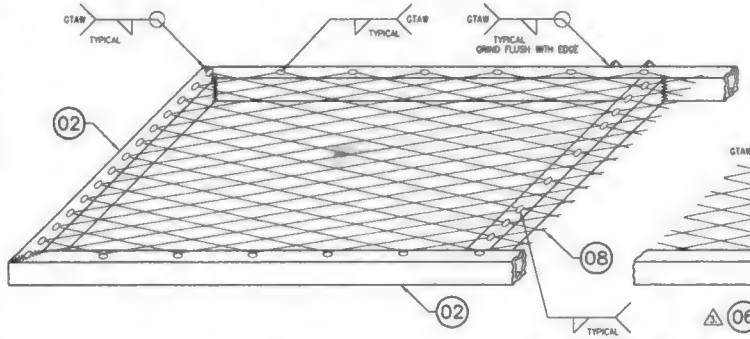
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE, CREATED FROM 60632, REV 0	BJC	09/08/2018
	HANDLE BRACKETS TO 842 CONFIG, REMOVE STEP SECTION SEE 70405		
	WELDS UPDATED, NOTES UPDATED, SECTION D-D ADDED		



DETAIL C
SCALE 1 : 1

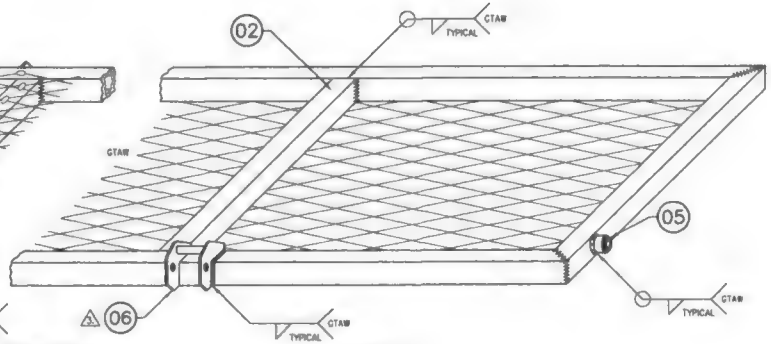


(01) BASKET LID ASSEMBLY



DETAIL B
LOOKING AT BOTTOM

ATTACHMENT OF MESH TO CROSS MEMBERS.
WELD FIRST FIVE INTERSECTIONS
THEN EVERY SECOND INTERSECTION
ADDITIONAL WELDS ARE PERMITTED AS REQUIRED



DETAIL A
LOOKING AT TOP

NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
   STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
3. INSTALL ITEM 6 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263
4. DRILL Ø30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY

SECTION D-D
SCALE 1:2

A/R	3/4-18F	08	MESH		COMMERCIAL	16 GAUGE
1	36204-10	07	PLACARD BRACKET			
1	84263-01	06	LID HANDLE BRACKET ASS'Y			
1	49216-01	05	LUG			
		04				
		03				
A/R	--	02	3/4" TUBE	4130 STEEL COND N	MIL-T-6736	0.75 X 0.035 SOR TUBE
	60632-01	01	BASKET LID ASSEMBLY			
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	
QTY	LIST OF MATERIALS					

APPROVALS		DATE
DRAWN:	JEFF CLARKE	09 AUG 2018
CHECKED:	JASON REKVE	09 AUG 2018

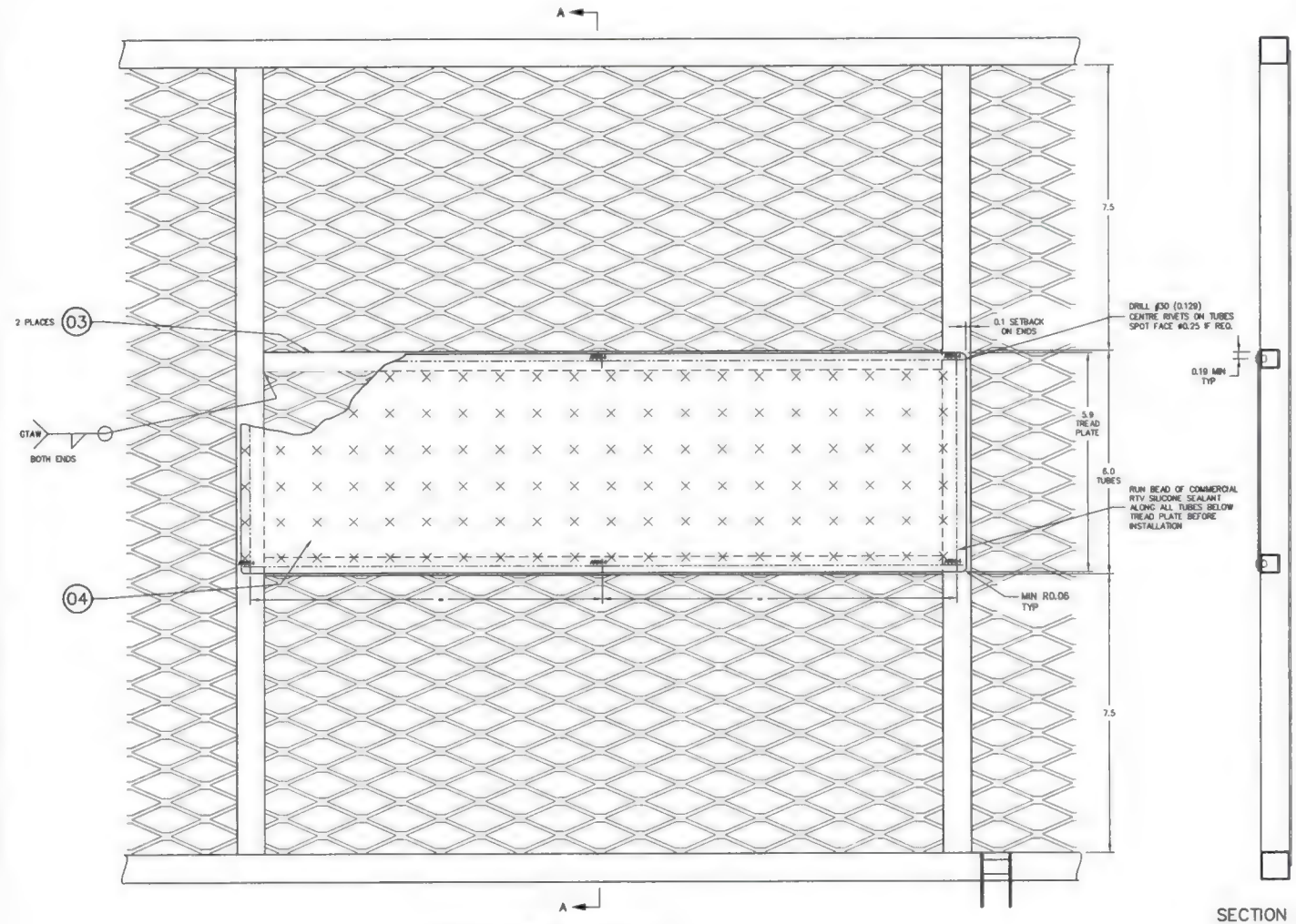
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
9688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2378 www.aerodesign.ca

BELL 407, 206L SERIES
HIGH SIDE MOUNTED CARGO BASKET
CARGO BASKET LID ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV
SHEET 1 OF 1	A1	76612	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014



(01) BASKET LID ASSEMBLY

SECTION A–A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02		BLIND RIVET	ALTERNATE. HR3213-4-02		
1	70405-04	04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02	BASKET LID ASSEMBLY			
	70405-01	01	BASKET LID ASSEMBLY – MODIFIED WITH STEP			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF MAS 523

DASH NO. FOR DIAMETER
N=MFD. HEAD NEAR SIDE
F=MFD. HEAD FAR SIDE

C=COUNTERSUNK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED

DASH NO. FOR LENGTH

BASIC CODES:
BJ=MS20470AD
BB=MS20426AD
ARN=CR3213
ARM=CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS		DATE
DRAWN:	JEFF CLARKE	21 SEPT 2006
CHECKED:	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
9668A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G5
TEL: 604.485.3376 www.aerodesign.ca

CARGO BASKET
LID STEP MODIFICATION

SCALE 1 : 1.5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	70405	4

2017-163 X(7)
1-5

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 0 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 1 – Short Basket
69812, Revision 3 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 0 – Standard Basket

Bell Medium – left or right
75112, Revision 0 – Standard Basket
95512, Revision 0 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
70405, Revision 3 – Walkway
70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2017-163

Date Open: Oct 2017

1. Rim Assembly – Basket Lid
   a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

2. Weld Rim Assembly
   a. Record welding rod PO on attached material list.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

3. Inspection
   a. Rim for complete welds

AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02

4. Frame assembly – Lid
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
   b. Insert rim from step 2 into jig.
   c. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.
   d. Record material PO on attached material list.
   e. Remove writing on tubes with acetone and scotch bright.
   f. Drill vent holes into rim to vent cross members into rim.
   g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

5. Frame assembly – Lid with optional walkway modification
   a. Fit cross members to rim in accordance with step 4.
   b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
   c. Cut ½" x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
   d. Drill vent holes into cross members at walkway stingers.
   e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

6. Weld frame assembly.
   a. Record welding rod PO on attached material list.
   b. Jigs must remain in place for as long as practical during welding.

AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02

7. Inspection
   a. Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

Complete (initial or SCA #)

8. Mesh assembly. JF JF JF JF JF AD 73-04 02

   Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

   a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
   b. Cut mesh to size for lid.
   c. Remove surface rust with scotch-brite.
   d. Ensure lid is prepared for mesh on the correct side. AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05

9. Weld mesh to frame assembly per drawing.

   a. General welding requirements for all lids:
      i. Every intersection on all edges.
      ii. First 5 intersections along cross members, then every second intersection.
   b. MIG weld both short sides.
   c. Clamp lid over spacer at centre of lid to pre-tension mesh.
      i. ¾" for lids under 76"
      ii. 1" (check) for lids over 76"
   d. Weld remainder of mesh as indicated in a.
   e. Record welding rod PO on attached material list. AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05 AD 73-04 05

10. Weld lid components.

   a. Handle brackets, locate in accordance with drawing.
      i. Standard location: ¼" outside of last cross member on both ends.
      ii. Record handle bracket WO and welding rod PO on attached material list.
   b. Lid prop bushing(s).
      i. one or two in accordance with drawing.
      ii. Record lip prop bushing WO and welding rod PO on attached material list.
   c. Placard bracket. – not installed on 95912 (Bell 429)
      i. Locate on cross member to set bracket in centre bay of lid.
      ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up JF JF JF JF JF dk

   a. Grind high spots off mesh welds.
   b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
   c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
   d. Drill #9 through lid prop bushing(s). De-burr hole(s).
   ~~e. Drill for lid bumpers using 1/4" (#3) centre drill.~~
      ~~i. 3 places for lids under 76"~~
      ~~ii. 4 places for lids over 76"~~
   f. Remove surface rust with scotch-brite pad.

12. Final Inspection AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02 AD 73-04 02

   To be completed by a different person than the previous steps.

   a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
   b. Material lists complete.
   c. Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

13. Powder Coating
    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag lid assembly and place into stock in preparation for assembly.

2017-163 X(7)
6-7

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 0 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 1 – Short Basket
69812, Revision 3 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 0 – Standard Basket

Bell Medium – left or right
75112, Revision 0 – Standard Basket
95512, Revision 0 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
70405, Revision 3 – Walkway
70402, Revision 1 – Lid Door

6-7

CARGO BASKET LID FABRICATION

Work Order: 2017-163

Date Open: Oct 2017

	Complete (initial or SCA #)	
1. Rim Assembly – Basket Lid	AD 73-04 05	AD 73-04 05
a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.		
i. 1 or 2 lid prop bushing holes in short tube – refer to drawing		
b. Record material PO on attached material list.		
c. Remove writing on tubes with acetone and scotch bright.	AD 73-04 05	AD 73-04 05
2. Weld Rim Assembly		
a. Record welding rod PO on attached material list.	AD 73-04 02	AD 73-04 02
3. Inspection		
a. Rim for complete welds	AD 73-04 05	AD 73-04 05
4. Frame assembly – Lid		
a. General		
i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)		
b. Insert rim from step 2 into jig.		
c. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.		
d. Record material PO on attached material list.		
e. Remove writing on tubes with acetone and scotch bright.		
f. Drill vent holes into rim to vent cross members into rim.		
g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.	AD 73-04 05	AD 73-04 05
5. Frame assembly – Lid with optional walkway modification		
a. Fit cross members to rim in accordance with step 4.		
b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.		
c. Cut ½" x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.		
d. Drill vent holes into cross members at walkway stingers.		
e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.	AD 73-04 05	AD 73-04 05
6. Weld frame assembly.		
a. Record welding rod PO on attached material list.		
b. Jigs must remain in place for as long as practical during welding.	AD 73-04 02	AD 73-04 02
7. Inspection		
a. Frame assembly for complete welds.		

CARGO BASKET LID FABRICATION

Complete (initial or SCA #)

8. Mesh assembly. — J.F. — J.F. — AD 73-04 02
   Note: 95912 (Bell 429) does not have mesh. Skip to step 10.
   a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
   b. Cut mesh to size for lid.
   c. Remove surface rust with scotch-brite.
   d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing. — AD 73-04 05 — AD 73-04 05
   a. General welding requirements for all lids:
      i. Every intersection on all edges.
      ii. First 5 intersections along cross members, then every second intersection.
   b. MIG weld both short sides.
   c. Clamp lid over spacer at centre of lid to pre-tension mesh.
      i. ¾" for lids under 76"
      ii. 1" (check) for lids over 76"
   d. Weld remainder of mesh as indicated in a.
   e. Record welding rod PO on attached material list.

10. Weld lid components. — AD 73-04 05 — AD 73-04 05
    a. Handle brackets, locate in accordance with drawing.
       i. Standard location: ¼" outside of last cross member on both ends.
       ii. Record handle bracket WO and welding rod PO on attached material list.
    b. Lid prop bushing(s).
       i. one or two in accordance with drawing.
       ii. Record lip prop bushing WO and welding rod PO on attached material list.
    c. Placard bracket. – not installed on 95912 (Bell 429)
       i. Locate on cross member to set bracket in centre bay of lid.
       ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up — J.F. — J.F. — N/A
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
    c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
    d. Drill #9 through lid prop bushing(s). De-burr hole(s).
    ~~e. Drill for lid bumpers using 1/4" (#3) centre drill.~~
       ~~i. 3 places for lids under 76"~~
       ~~ii. 4 places for lids over 76"~~
    f. Remove surface rust with scotch-brite pad.

12. Final Inspection — AD 73-04 02 — AD 73-04 02
    To be completed by a different person than the previous steps.
    a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
    b. Material lists complete.
    c. Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

13. Powder Coating

    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag lid assembly and place into stock in preparation for assembly.

AD 73-04 02 _____ AD 73-04 02 _____

Work Order: 2017-163

Date Opened: Oct 2017

Material Tracking Sheet
Bell 206L / 407
HIGH Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	7		**60632-01**	**Lid Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	17055
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	17055
Step 2				*Weld Rim Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, ¾" x 0.035 Sqr. Tube	2017-153 (7) 17055 (21)
Step 5		70405		*Option: Frame Assembly - with walkway*		
	. 10		--	1/2" Tube - walkway	4130 Steel, ½" x 0.035 Sqr. Tube	17082
Step 6				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 7				*Inspection - Frame Assembly*	*None*	
Step 8				*Mesh Assembly*		
	. 1		--	Mesh (lid - 93" x 22")	3/4-16F Expanded Mild Steel sheet	17025
Step 9				*Weld Mesh*		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	16078

Work Order: 2017-163

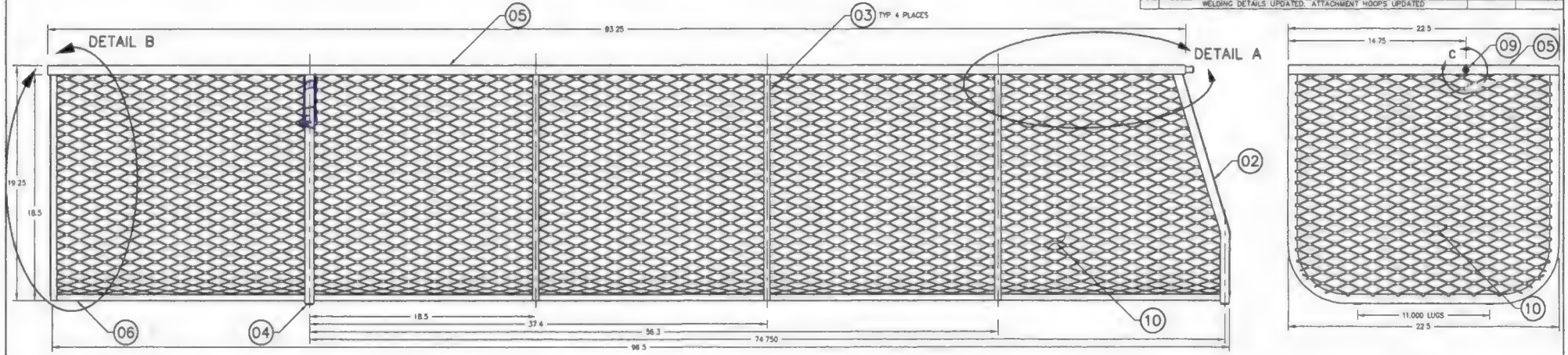
Date Opened: Oct 2017

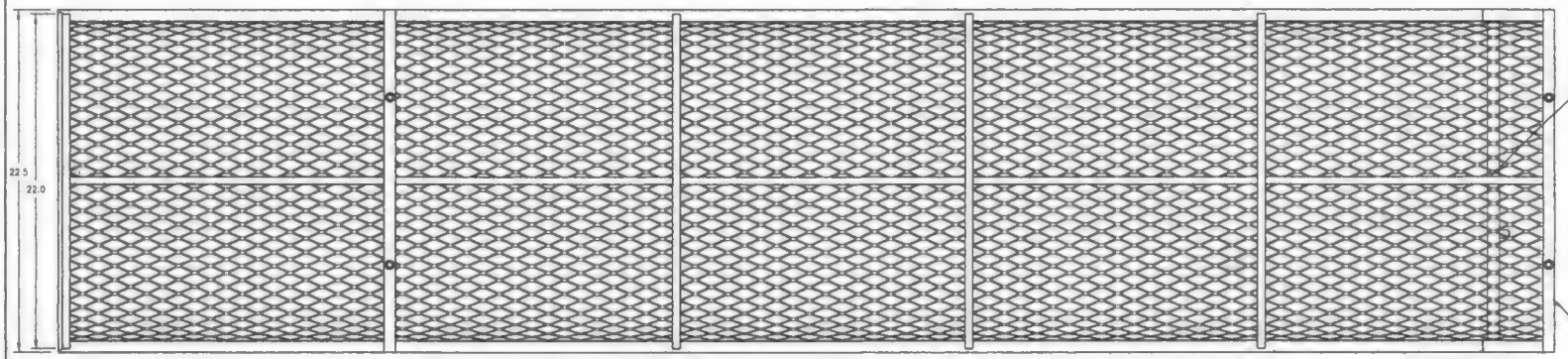
Material Tracking Sheet
Bell 206L / 407
HIGH Lid Fabrication

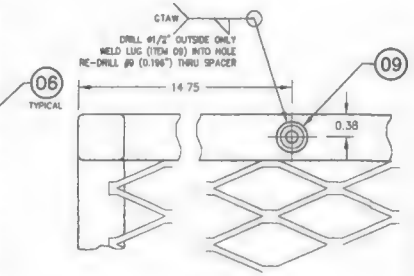
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				*Weld Lid Components*		
Step 10.a.	. 1	84263	84263-01	Lid Handle Bracket Assembly		2016-147
	. . 2		84263-02	Handle Bracket Assembly	321 Stainless, 0.050 Sheet	
	. A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 10.b.	. 2		49216-01	Spacer (Lid prop)	304 Stainless, ½" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 10.c.	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2016-119
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 11				*Clean Up*		
Step 12				*Inspection - Final Assembly*		
Step 13				*Powder Coating*		17105 / 17110 (6) (1)

2017-163 X(7)

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	TITLE BLOCK UPDATED. HANDLE BRACKETS CHANGED TO 842 CONFIGURATION	BJC	25/06/2017
	WELDING DETAILS UPDATED. ATTACHMENT HOOPS UPDATED		

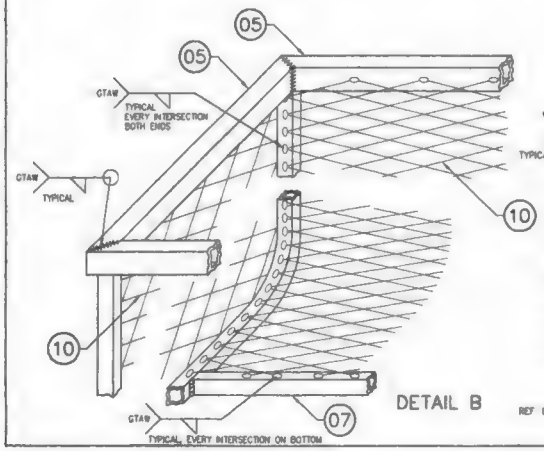




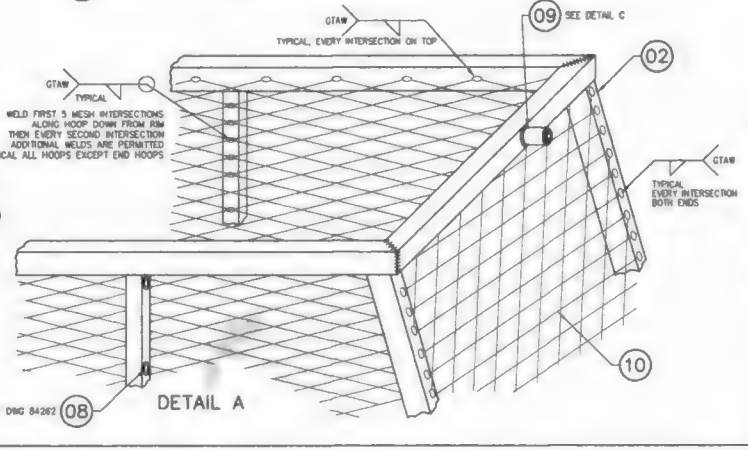


DETAIL C
SCALE 1:1
VIEW LOOKING AT RIM OF BASKET

(01) BASKET BODY ASSEMBLY



DETAIL B



DETAIL A

NOTES:
1) REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL Ø30 (0.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
4. INSTALL ITEM 8 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 BEFORE WELDING HOOPS TO RIM
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY

QTY.	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
A/R	3/4-18F	10	MESH		16 GAUGE	
1	49215-01	09	LUG			
1	84262-01	08	BASKET HANDLE PROVISIONS ASSEMBLY			
		07				
A/R	--	06	1/2" TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
A/R	--	05	3/4" TUBE	4130 STEEL COND N	MIL-T-6736	0.75 x 0.035 SQR TUBE
1	76625-01	04	ATTACHMENT HOOP			
4	76623-01	03	[illegible]			
1	76624-01	02	END HOOP ASS'Y			
1	76611-01	01	BASKET BODY ASSEMBLY			

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	JEFF CLARKE	25 SEPT 2007
CHECKED:	E. BURGOON	27 SEPT 2007

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
9688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0C3
TEL: 604.483.2276
www.aerodesign.ca

BELL 407, 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
CARGO BASKET BODY ASSEMBLY

SCALE	DWG SIZE	DWG NO	REV
1 : 4	A1	76611	1
SHEET 1 OF 1			

2017-163
1 – 5

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket → Rev. 1
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2017-163

Date Open: Oct 2017

1. Rim Assembly – Basket Body
   a. Cut and fit ¾" x 0.035 material to fit rim jig.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.
   d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
   e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.
   a. Record welding rod PO on attached material list.
   b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection
   a. Rim for complete welds

4. Frame assembly – body
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
   b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
   c. Pull required hoops from stock - standard, attachment, handle.
      i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
      ii. Ensure vent hole is located at centre of tube to vent spine tubes.
   d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
      i. Ensure correct order and orientation of hoops. Refer to drawing.
         1. Attachment lugs are on inboard side.
         2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
      ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
      iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
      iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
      v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
   e. Cut ½" x 0.035 material to fit spine jig.
   f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
      i. Refer to applicable drawing for position, not required on some baskets.
   g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
   h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
   i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

Complete
(initial or SCA #)

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly. AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

6. Inspection AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05
    a. Frame assembly for complete welds.

7. Mesh assembly. JF | JF | JF | JF | JF
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete (initial or SCA #)

8. Weld mesh to frame assembly per drawing.
   a. Ensure lug locating jig is in place prior to welding.
   b. General welding requirements for all baskets, MIG welding:
      i. Every intersection at top edges.
      ii. Every intersection at ends.
      iii. First 5 intersections down on hoops, then every second intersection.
      iv. Every intersection along spine.
      v. Extra large baskets – every intersection along corner.
      vi. Every intersection around ends
      vii. Every intersection along struts (if applicable)
   c. Bend and trim cells bent in to fit mesh as required and weld in position.
   d. Grind high spots off body mesh welds on ends before welding end mesh.
   e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
   f. Record welding rod PO on attached material list.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

9. Weld basket components
   a. TIG weld lid prop bushing(s), one or two per drawing.
      i. Record welding rod PO on attached material list.
      ii. Record lip prop bushing WO on attached material list.
   b. TIG weld caps to close top of 1" hoops as applicable.
   c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
      i. Cut inboard rim on aft end. Grind flush with hoops.
      ii. TIG weld caps on open tubes.
      iii. Record cap material PO on attached material list.
   d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
      i. Record welding rod PO on attached material list.
      ii. Record placard bracket WO on attached material list.

AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05 | AD 73-04 05

10. Clean up
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    ~~c. Drill #9 through lid prop bushing(s). De-burr hole(s).~~
    d. Remove surface rust with scotch-brite pad.

J.f. | J.f. | J.f. | J.f. | J.f. d/R

11. Final Inspection

    To be completed by a different person than the previous steps.
    a. Basket body assembly for complete welds, and required minimum mesh weld locations.
    b. Filled vent holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
       i. Hoops for height.
       ii. Rim for width and length and alignment.
       iii. Lid prop lugs in correct ends.
       iv. Fore/aft strut in hoop if required by drawing.
    d. Material lists complete.

AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02 | AD 73-04 02

Complete
(initial or SCA #)

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

a. Parts are to be powder coated white in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag basket body assembly and place into stock in preparation for assembly.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

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CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket ← Rev 1
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

6-7

CARGO BASKET BODY FABRICATION - COMMON

Complete (initial or SCA #)

Work Order: 2017-163

Date Open: Oct 2017

1. Rim Assembly – Basket Body — AD 73-04 05 | AD 73-04 05
   a. Cut and fit ¾" x 0.035 material to fit rim jig.
      i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
   b. Record material PO on attached material list.
   c. Remove writing on tubes with acetone and scotch bright.
   d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
   e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim. — AD 73-04 05 | AD 73-04 05
2. Weld Rim Assembly. — AD 73-04 05 | AD 73-04 05
   a. Record welding rod PO on attached material list.
   b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube. — AD 73-04 05 | AD 73-04 05
3. Inspection — AD 73-04 05 | AD 73-04 05
   a. Rim for complete welds
4. Frame assembly – body — AD 73-04 05 | AD 73-04 05
   a. General
      i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
   b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
   c. Pull required hoops from stock - standard, attachment, handle.
      i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
      ii. Ensure vent hole is located at centre of tube to vent spine tubes.
   d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
      i. Ensure correct order and orientation of hoops. Refer to drawing.
         1. Attachment lugs are on inboard side.
         2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
      ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
      iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
      iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
      v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
   e. Cut ½" x 0.035 material to fit spine jig.
   f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
      i. Refer to applicable drawing for position, not required on some baskets.
   g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
   h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
   i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

AD 73-04 05 | AC 73-04 05

5. TIG weld frame to rim assembly.
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

AD 73-04 05 | AD 73-04 05

6. Inspection
    a. Frame assembly for complete welds.

JF | JF AF

7. Mesh assembly.
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

AD 73-04 05 | AD 73-04 05 | **Complete** (initial or SCA #)

8. Weld mesh to frame assembly per drawing.
    a. Ensure lug locating jig is in place prior to welding.
    b. General welding requirements for all baskets, MIG welding:
        i. Every intersection at top edges.
        ii. Every intersection at ends.
        iii. First 5 intersections down on hoops, then every second intersection.
        iv. Every intersection along spine.
        v. Extra large baskets – every intersection along corner.
        vi. Every intersection around ends
        vii. Every intersection along struts (if applicable)
    c. Bend and trim cells bent in to fit mesh as required and weld in position.
    d. Grind high spots off body mesh welds on ends before welding end mesh.
    e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
    f. Record welding rod PO on attached material list.

AD 73-04 05 | AD 73-04 05

9. Weld basket components
    a. TIG weld lid prop bushing(s), one or two per drawing.
        i. Record welding rod PO on attached material list.
        ii. Record lip prop bushing WO on attached material list.
    b. TIG weld caps to close top of 1" hoops as applicable.
    c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
        i. Cut inboard rim on aft end. Grind flush with hoops.
        ii. TIG weld caps on open tubes.
        iii. Record cap material PO on attached material list.
    d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
        i. Record welding rod PO on attached material list.
        ii. Record placard bracket WO on attached material list.

J.F. | J.F. AR

10. Clean up
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    ~~c. Drill #9 through lid prop bushing(s). De-burr hole(s).~~
    d. Remove surface rust with scotch-brite pad.

AD 73-04 02 | AD 73-04 02

11. Final Inspection

    To be completed by a different person than the previous steps.
    a. Basket body assembly for complete welds, and required minimum mesh weld locations.
    b. Filled vent holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
        i. Hoops for height.
        ii. Rim for width and length and alignment.
        iii. Lid prop lugs in correct ends.
        iv. Fore/aft strut in hoop if required by drawing.
    d. Material lists complete.

Complete
(initial or SCA #)

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

a. Parts are to be powder coated white in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag basket body assembly and place into stock in preparation for assembly.

AD 73-04 02 AD 73-04 02

Work Order: 2017-163

Date Opened: Oct 2017

Material Tracking Sheet
Bell 206L / 407
HIGH Basket Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	7		**76611-01**	**Basket Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	17055
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	17055
Step 2				*Weld Rim Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		76623-01	Hoop - standard	4130 Steel, ½" x 0.035 Sqr. Tube	See hoop sheets
	. 1		76621-01	Forward Attachment Hoop		See hoop sheets
	. 1		76622-01	Aft Attachment hoop		See hoop sheets
	. 4		--	1/2" Tube - spine	4130 Steel, ½" x 0.035 Sqr. Tube	17082
Step 5				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 6				*Inspection - Frame Assembly*	*None*	
Step 7				*Mesh Assembly*		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	16009
	. 2		--	Mesh (End - 22" x 19")	3/4-16F Expanded Mild Steel sheet	17025
Step 8				*Weld Mesh*		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	16078
Step 9				*Weld Basket Components*		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	17066

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Material Tracking Sheet
Bell 206L / 407
HIGH Basket Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				*Clean Up*	*None*	
Step 11				*Inspection - Final Assembly*	*None*	
Step 12				*Powder Coating*		17105 / 17110 (6) (1)

407 High

01 Nov 2017

X0 @ end of cut - ℄

SLOT SAW Y0 @ face of tube Ø4.0 x 1/2" slot saw

200 RPM

move in to +0.200 in Y @ X 0.5

Feed across to ~~X0.5~~ X0.0 @ 1.28

retract

Some drag on Y on entrance

Lock Y while moving X

1st then

- Center punch @ center, 2" down from cut
- drill Ø1/4 center drill
- drill Ø1/2 center drill

on drill press
open belt cover,
hoop just fits over pulley